

SHIP MON OCT 31

Work Order ID 75663 - 1

75663

Page 1

October-27-11 2:41:07 PM

Item ID: D2662-2 **SPLIT** Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH In 206
 Start Date: 10/27/11 Start Qty: 11.00 ***11*** Cust Item ID:
 Required Date: 11/01/11 Req'd Qty: 11.00 ***11*** Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2662	Rev D

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.
 Inspect part number and batch number are programmed

SL 11-10-30



MACHINE AS PER FOLIO FB069 & DWG

DWG REV: D
 FOLIO REV: AA

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11-10-30

11

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	SL	11-10-30		11			
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	11-10-30		11			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				11	11-10-31		

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October-27-11 2:41:07 PM

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Start Date: 10/27/11 Start Qty: 11.00 ***11*** Cust Item ID:
 Required Date: 11/01/11 Req'd Qty: 11.00 ***11*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
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150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE:

11/10/31

160	QC3- Inspect Part Finish	0.00							
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160

QC

Quality Control

Memo

0.00

11/10/31

170	Identify as per dwg & Stock Location: _____	0.00							
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170

Packaging

Packaging

Memo

0.00

11/10/31

Picklist Print

October-27-11 2:41:06 PM

Page 1

Work Order ID: 75663

Parent Item: D2662-2

Start Date: 10/27/11

Required Date: 11/01/11

Parent Item Name: Saddle, RH In 206

Start Qty: 11.00

Required Qty: 11.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	271.0000	1	11			

21 11-10-30

Location

Loc Qty

Loc Code

MAT040

271

66965

1

69677

2

73774

60

73779 ✓

60

74648

80

74679

68

14

DART AEROSPACE LTD	Work Order:	7.5663
Description: 206 Saddle, Inboard, Right side	Part Number:	D2662-2
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	* Date
				1	2	3	4		
A	0.100	0.140		.121	.120	.120	.130	.121	.120
B	0.100	0.140		.150	.152	.131	.131	.127	.150
C	1.125	1.145		1.134	1.135	1.140	1.136	1.137	1.135
D	0.615	0.685		.680	.680	.680	.680	.680	.680
E	0.240	0.260		.250	.254	.251	.254	.252	.252
F	1.313	1.343		1.323	1.327	1.328	1.328	1.327	1.325
G	0.210	0.230		.224	.221	.222	.223	.222	.220
H	0.100	0.180		.130	.130	.130	.130	.130	.130
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.490
J	1.565	1.585		1.574	1.575	1.579	1.576	1.577	1.575
K	0.235	0.240		.237	.238	.238	.238	.238	.238
L	0.100	0.120		.114	.113	.113	.113	.113	.113
M	0.990	1.010		.990	.990	.990	.990	.990	.990
N	0.510	0.515		.512	.512	.512	.512	.512	.512
O	5.990	6.010		5.996	5.996	5.995	6.003	6.004	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318		.313	.313	.313	.313	.313	.313
S	0.315	0.322		.316	.316	.316	.316	.316	.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.797	.794	.794	.795	.799	.797
W	0.540	0.560		.549	.549	.550	.549	.550	.549
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	1.679
Y	0.257	0.262		.257	.257	.257	.257	.257	.257
Z	0.912	0.932		.919	.921	.919	.922	.924	.922
AA	0.490	0.510		.498	.498	.497	.502	.502	.500
AB	0.178	0.198		.188	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>SL</i>	Audited by:	<i>ony</i>
Date:	11-10-29	Date:	11/10/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	75663
Description: 206 Saddle, Inboard, Right side	Part Number:	D2662-2
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				4	8	9	10		
A	0.100	0.140		.120	.120	.120	.120	.120	.121
B	0.100	0.140		.135	.135	.135	.135	.132	.134
C	1.125	1.145		1.136	1.135	1.136	1.139	1.138	1.138
D	0.615	0.685		.680	.680	.680	.680	.680	.680
E	0.240	0.260		.252	.251	.251	.249	.249	.249
F	1.313	1.343		1.324	1.324	1.324	1.324	1.324	1.324
G	0.210	0.230		.222	.220	.220	.220	.220	.220
H	0.100	0.180		.130	.130	.130	.130	.130	.130
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.490
J	1.565	1.585		1.576	1.575	1.576	1.579	1.578	1.578
K	0.235	0.240		.238	.238	.238	.238	.238	.238
L	0.100	0.120		.113	.113	.113	.113	.113	.113
M	0.990	1.010		.990	.990	.990	.990	.990	.990
N	0.510	0.515		.512	.512	.512	.512	.512	.512
O	5.990	6.010		6.004	6.004	6.004	6.004	6.004	6.004
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318		.313	.313	.313	.313	.313	.313
S	0.315	0.322		.316	.316	.316	.316	.316	.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.799	.799	.799	.800	.799	.799
W	0.540	0.560		.550	.550	.550	.550	.550	.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	1.679
Y	0.257	0.262		.257	.257	.257	.257	.257	.257
Z	0.912	0.932		.922	.923	.923	.923	.922	.922
AA	0.490	0.510		.502	.502	.502	.502	.501	.502
AB	0.178	0.198		.188	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	2
Date:	11-10-09

Audited by:	enl
Date:	11/10/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695, A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 75663
Description: 206 Saddle, Inboard, Right side	Part Number: D2662-2
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13	14	1	10		
A	0.100	0.140		.120	.121				
B	0.100	0.140		.135	.135				
C	1.125	1.145		1.139	1.140				
D	0.615	0.685		.680	.680				
E	0.240	0.260		.250	.250				
F	1.313	1.343		1.325	1.325				
G	0.210	0.230		.220	.221				
H	0.100	0.180		.130	.130				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.579	1.580				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.113	.113				
M	0.990	1.010		.990	.990				
N	0.510	0.515		.512	.512				
O	5.990	6.010		6.004	6.004				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.313	.313				
S	0.315	0.322		.316	.316				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.799	.799				
W	0.540	0.560		.549	.550				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.257	.257				
Z	0.912	0.932		.924	.923				
AA	0.490	0.510		.502	.502				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: SL
Date: 11-10-30

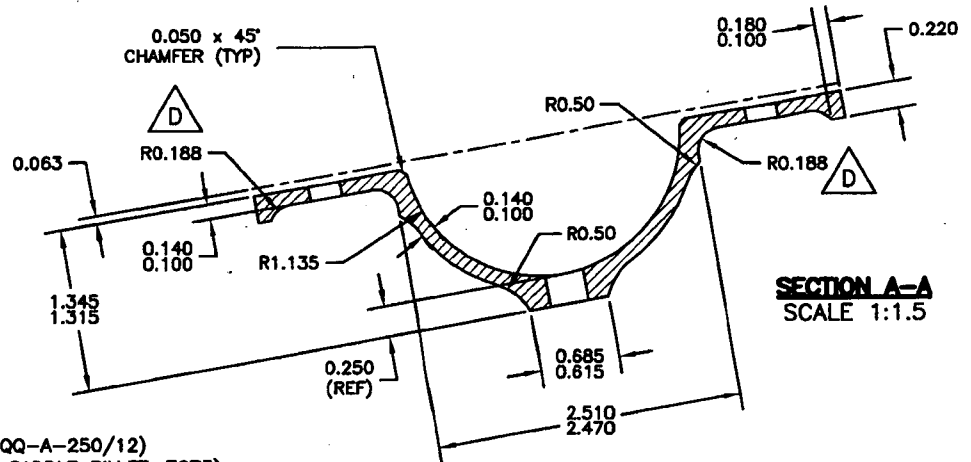
Audited by: CMR
Date: 11/10/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/JLM	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

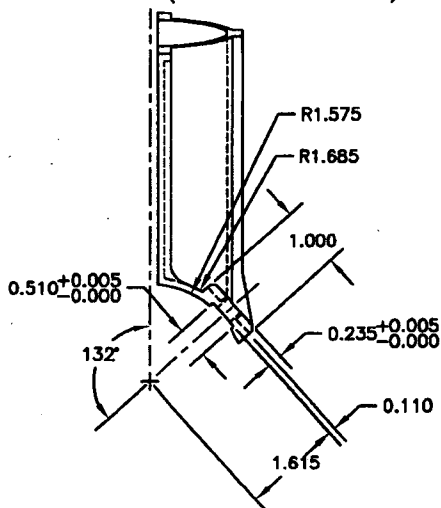
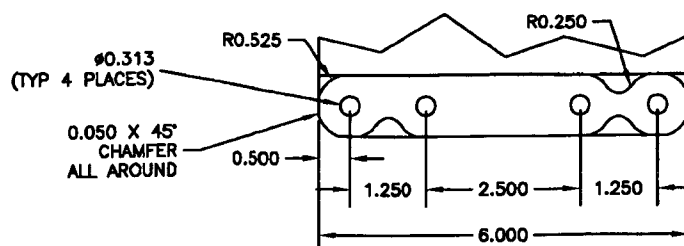
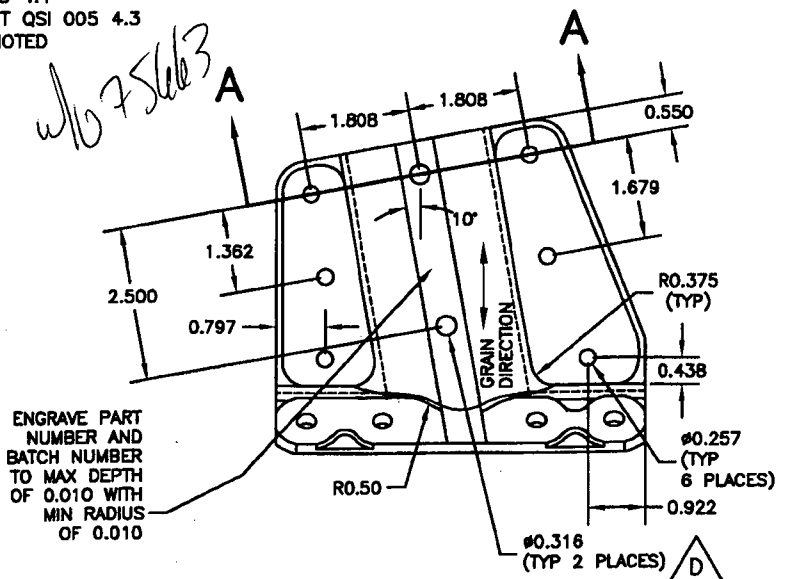
DART

DESIGN <i>A</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

RELEASED

07.02.02 *[Signature]***NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE**

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